



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4149-3**Job Sheet 192776****Part No:** D4149-3**Job Qty:** 30 pcs**Part Name:** Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/2/19**Job Tracking No:****Due Date:** 4/22/19 *April 30***Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV C IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD IPP Rev:B 11.03.03 as per revC DD
verf:JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Bandsaw - 1	30 pcs	4/22/19	4/22/19	0.00	0.10	Bandsaw - 1	<i>mm 19/04/30</i>
110	HAAS 4 Axis - B4B	30 pcs	4/22/19	4/22/19	0.12	13.10	HAAS - 1 - B4B	<i>mm L 19/04/30</i>
							HAAS - 2 - B4B	
							HAAS - 3 - B4B	
							HAAS - 4 - B4B	
130	QC 8	30 pcs	4/22/19	4/22/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	<i>K+ 19-04-30</i>
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
170	Packaging 3-1 - Stock - B4B	30 pcs	4/22/19	4/22/19	0.00	0.00	Packaging 3 - 1 - B4B	

Plex 4/2/19 8:17 AM Dart.lajeunesse.marie

**Container No:** S176718**Part:** D4149-3**Job No:** 192776**Serial No/Batch:** S176718**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's

Date: 04/30/19

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	PC 51089
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	30 pcs	4/22/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Bandsaw)

Descriptions: 110 - (HAAS CNC Vertical Machine)

130 - (QC8- Inspect parts - second check)

170 - (Identify as per dwg & Stock Location: _____)

180 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303B1.000X1.000 M9-C	M304B1.000 X 1.000	10 ft (.33333333 ea)	100-Bandsaw - 1	5172912

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M303B1.000X1.000	10	9	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	.122
2	Spacer	0.380Inches ± 0.030	0.410 0.350	Diameter	.379
3	Spacer	0.630Inches ± 0.030	0.660 0.600		.630
4	Spacer	1.588Inches ± 0.010	1.598 1.578		1.588
5	Spacer	2.430Inches ± 0.030	2.460 2.400		2.436
6	Spacer	0.630Inches ± 0.030	0.660 0.600		.630
7	Spacer	1.587Inches ± 0.010	1.597 1.577		1.587
8	Spacer	0.750Inches ± 0.030	0.780 0.720		.752
9	Spacer	0.313Inches ± 0.010	0.323 0.303		.312
10	Spacer	0.380Inches ± 0.030	0.410 0.350	Radius	.380
11	Spacer	0.375Inches ± 0.010	0.385 0.365		.375
12	Spacer	0.750Inches ± 0.010	0.760 0.740		.750
13	Spacer	0.735Inches + 0.000 - 0.010	0.735 0.725		.733

Plex 4/2/19 8:17 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
		Other/Details:			